

Date: Monday, 1/8/2007 10:44:16 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 30139		
Estimate Number	: 10732		
P.O. Number	: <i>N/A</i>	Part Number	: D23241
This Issue	: 1/8/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2324 REV. C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28914	Drawing Revision	: C
	Type : SMALL / MED FAB	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	30139A	STOP
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*Case mat scan*

Comment: Sub-Component STOP

1 X D2324-3 B *30139 A x20*

2.0	30139B	STRAP
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Comment: Sub-Component STRAP

2 X D2324-5 B *B25820B x1* *B28914 B x25* *B28062 x14* ✓

3.0	AN312A	Bolt
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✓

Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt *M18310*

4.0	AN960JD10	Washer
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✓

Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer *M100274 x 76 / M16822 x 4*

5.0	MS21042L3	Nut
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✓

Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut *M102214*

*M107/03/02*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/8/2007 10:44:17 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 30139

Part Number: D23241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2324.

*ml 07/03/02*

*X20*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 07/03/02*

*20*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*YJ / M-R*

*07-03-06 20*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*07/03/08 20*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*07/03/08 20*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/03/08*

Job Completion



*U 07-03-08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

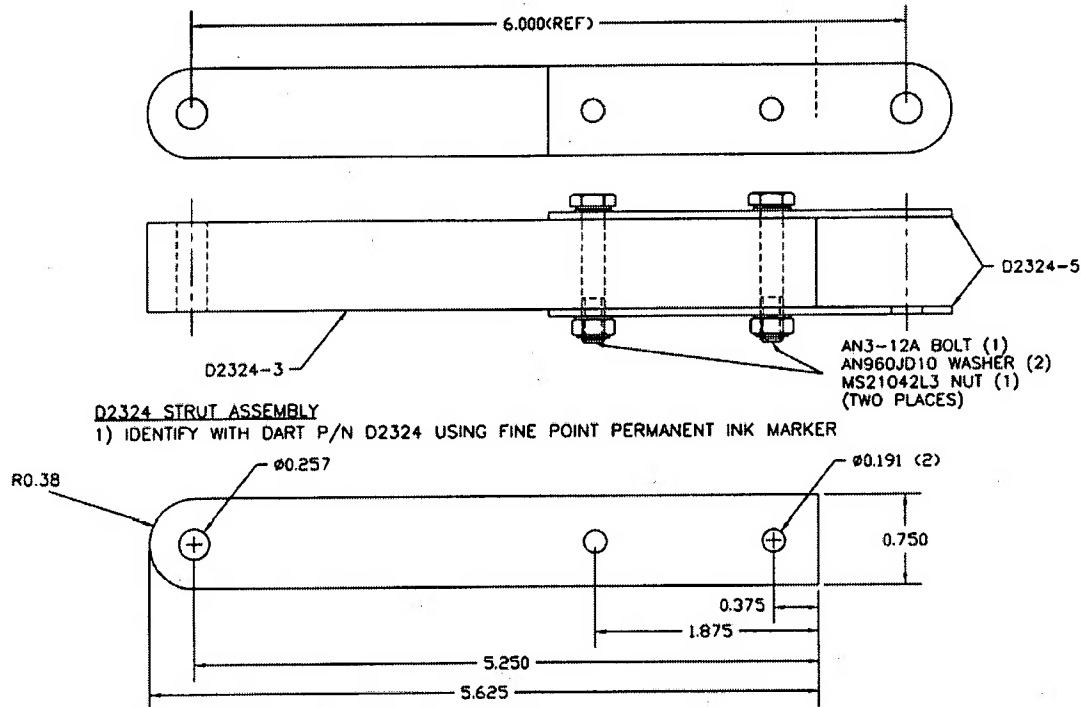
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

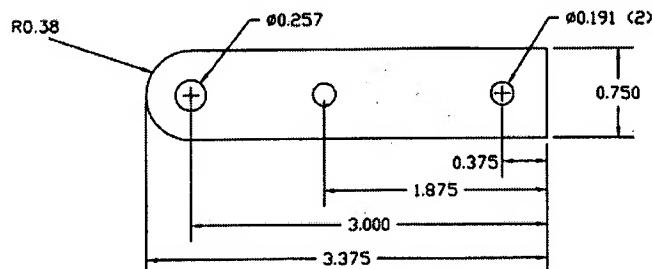
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT	SCALE	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED  
04.12.16 *[Signature]*

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30139